

Date: Thursday, 5/10/2007 2:25:41 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE
 Job Number : 32281
 Estimate Number : 10617
 P.O. Number : N/A Part Number : D265633
 This Issue : 5/10/2007 S.O. No. : N/A Drawing Number : D2656 REV D
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : D
 Previous Run : 29452 Material : N/A
 Due Date : 5/30/2007 Qty: 25 Um: Each
 Written By : Kim Johnston
 Checked & Approved By : Kim Johnston
 Comment : Est: D 02.10.25 Re-format KJ
 Est Rev:E 06-08-21 Now On Water JET JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S20GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.4074 sf(s)/Unit Total : 10.1850 sf(s)

1010/1025/A21/6aA SHEET 20 GAUGE

Batch: M104184 (17)

M102684 (6)

SAD

07/05/12

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2656

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

JLM 07/05/16

25

SAD 07/05/12

26

27

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/12

26

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SAD 07-05-13

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326.

2-Identify as D2656-33.

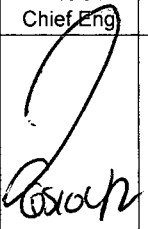
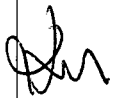
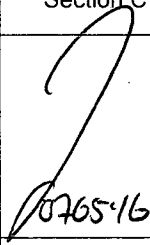
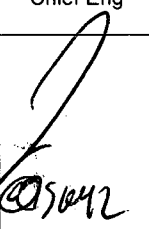
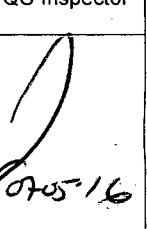
SAD 07/05/16

25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/16

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/16	4	1 piece was not good		Scrap + destroy	07/05/16 			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:25:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32281

Part Number: D265633

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2005-17 28

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101601

MJ 07-05-22 25

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-l 07/05/23 25x

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-15

m-l 07/05/23 25x

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/25 25

Job Completion



U 0705-25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

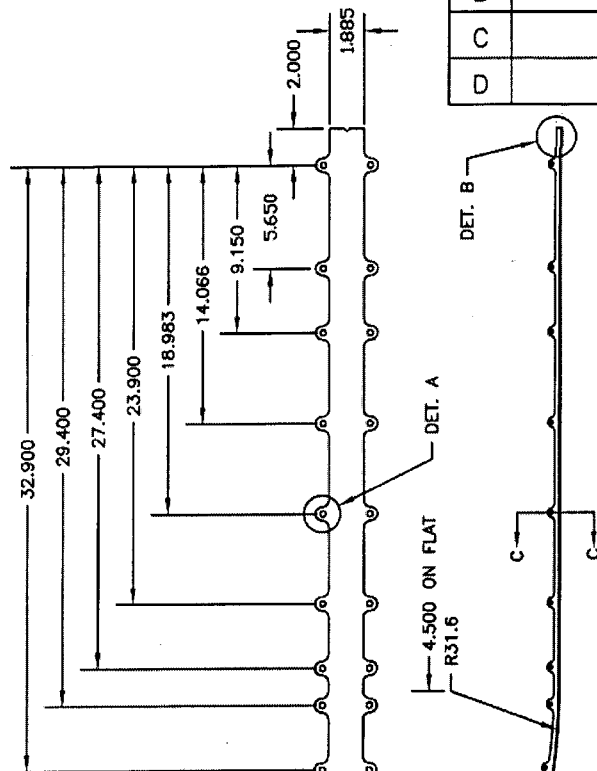
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

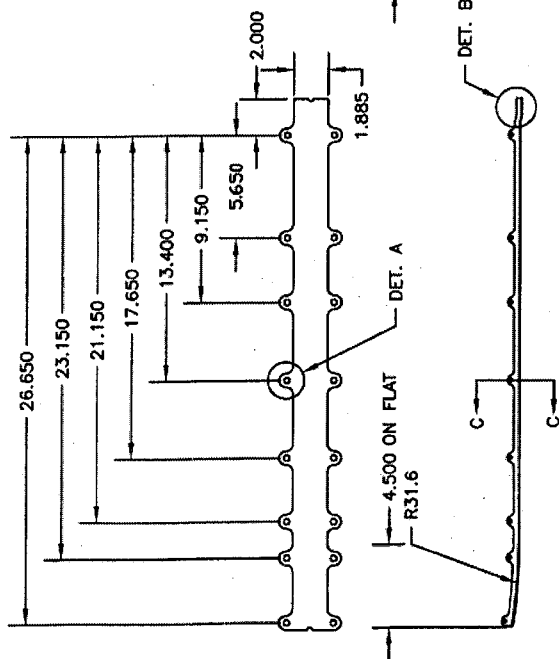


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2656	REV. D SHEET 1 OF 4
DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10
A	97:03:25	NEW ISSUE	
B	97:06:02	CHANGED TABS	
C	97:06:26	R31.6 WAS R19.5	
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT	

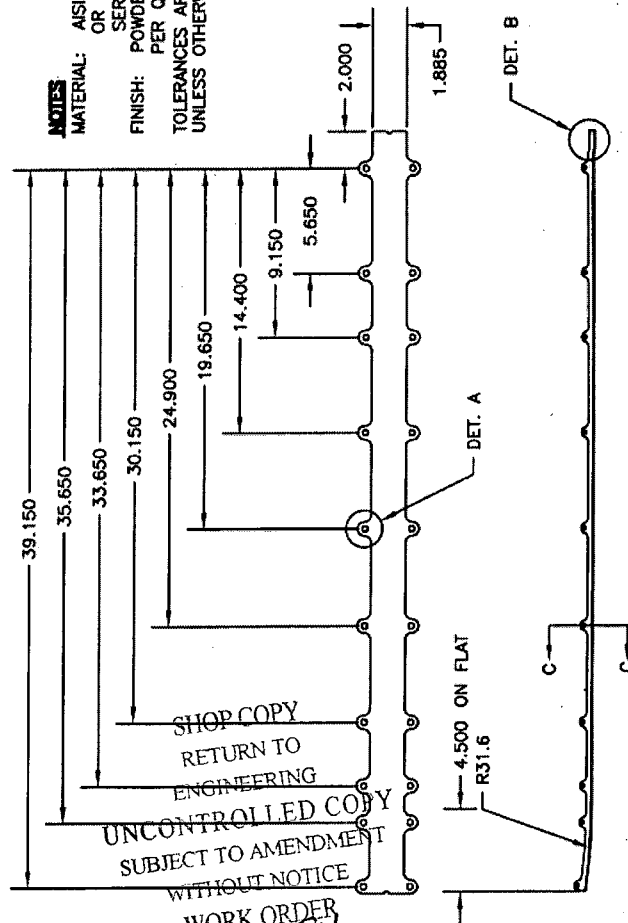
D2656-13



D2656-11



D2656-15



NOTES:
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED.

RELEASED
05.09.08

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WORK ORDER
NO. 32281

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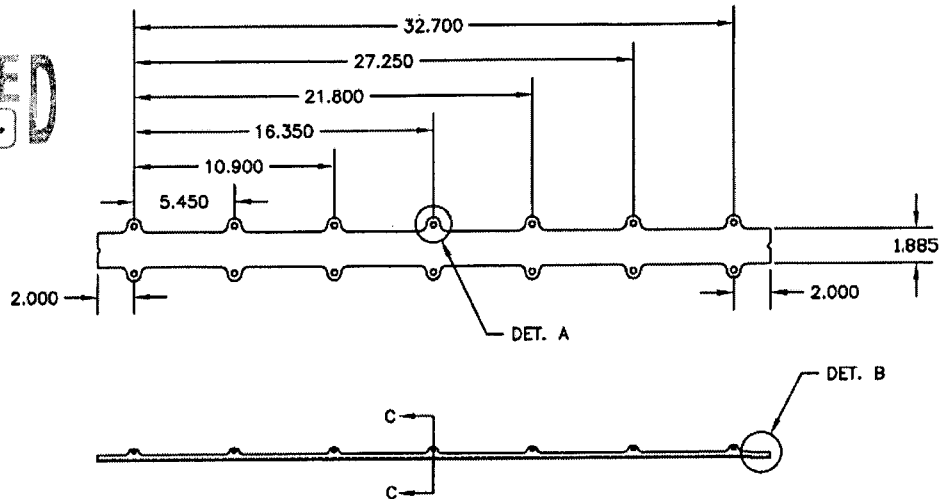
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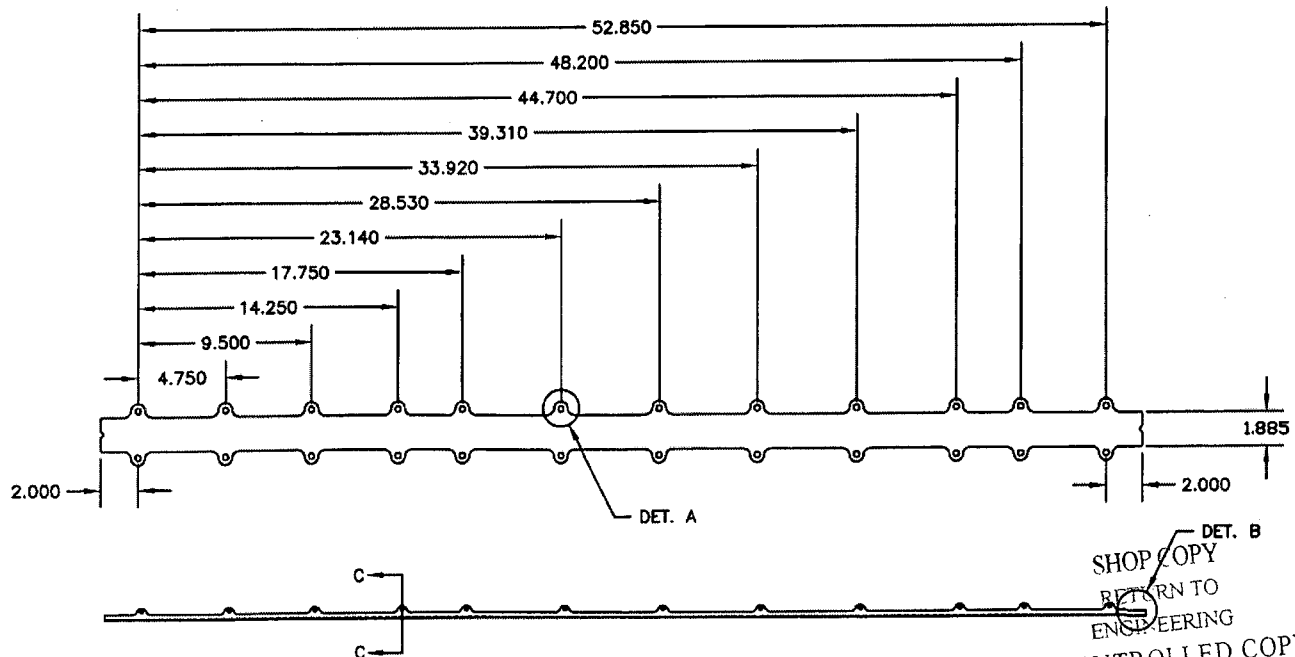
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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DS-07.d6

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
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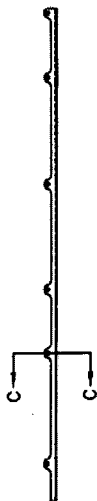
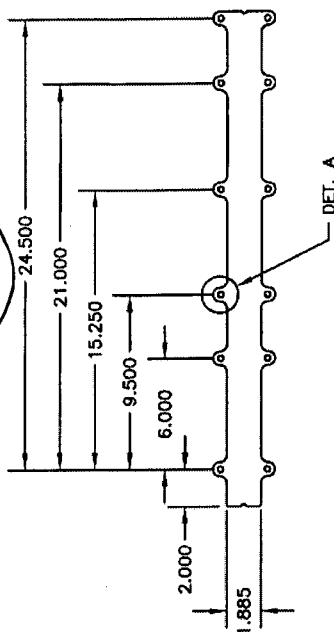
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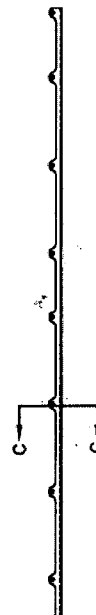
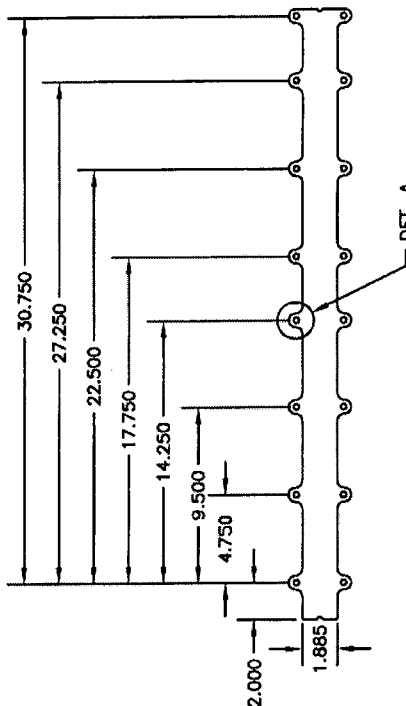


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				D2656	SHEET 3 OF 4
DATE				TITLE	SCALE
05.08.17				WEARSHOE	1:10

D2656-33

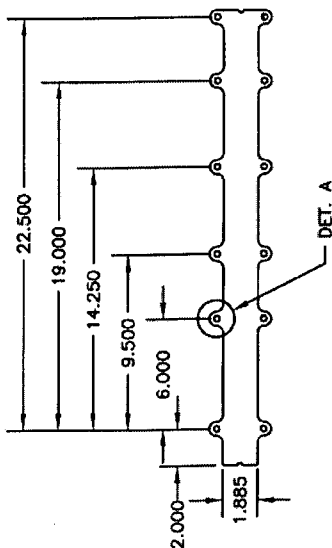


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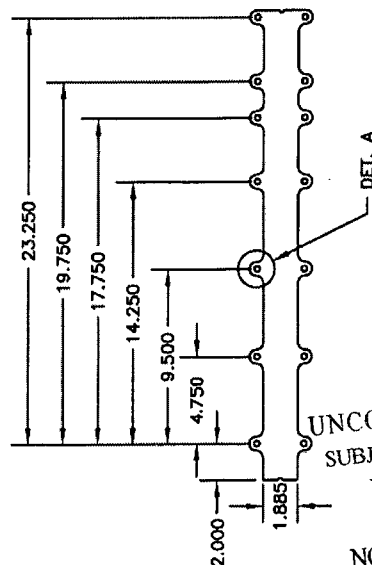


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FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

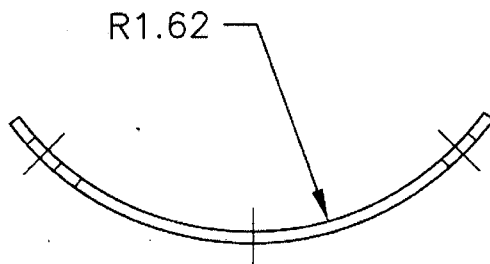
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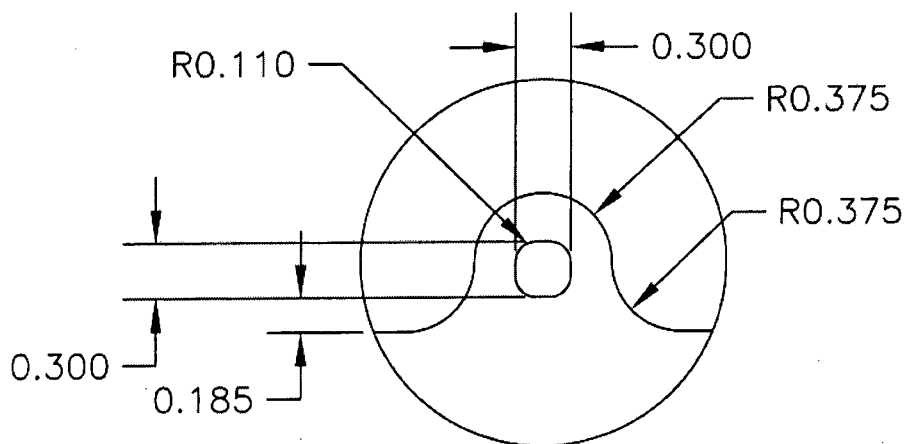
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

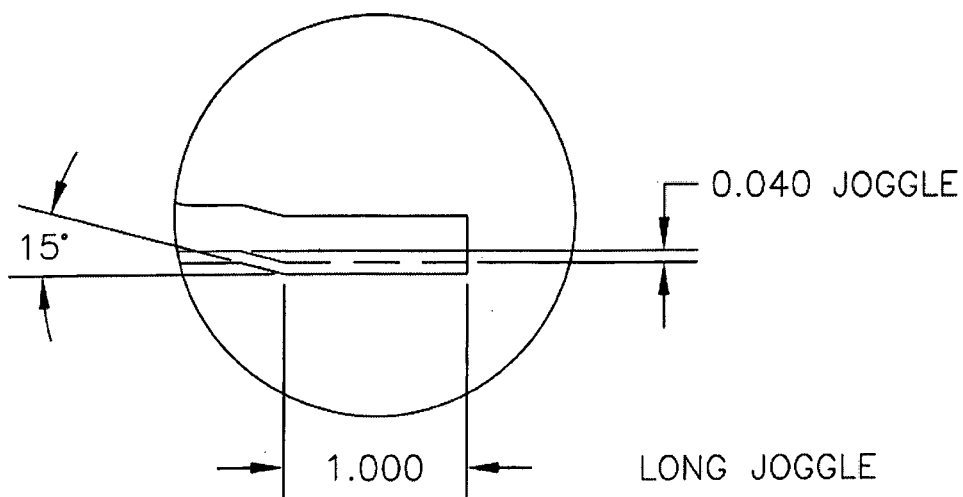


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DETAIL A



DETAIL B



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
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DART AEROSPACE LTD		Work Order: 32281
Description: BEARPAW WEARSHOE		Part Number: D265633
Inspection Dwg: D2656 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 24.500	+/- 0.010	24.500	✓		M-T	
B 21.000	+/- 0.010	21.000	✓		M-T	
C 15.250	+/- 0.010	15.250	✓		M-T	
D 9.500	+/- 0.010	9.492	✓		Vern	
E 6.000	+/- 0.010	6.000	✓		Vern	
F 2.000	+/- 0.010	2.001	✓		Vern	
G 1.885	+/- 0.010	1.888	✓		Vern	
H 0.300	+/- 0.010	0.299	✓		Vern	
I 0.300	+/- 0.010	0.300	✓		Vern	
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD	Audited by: 	Prototype Approval:	N/A
Date: 07/05/12	Date: 07.05.13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	

